

Work Order ID 53354

November 2, 2009 10:43:05 AM

Blue ASAP

SPLIT-2



Page 1

Item ID: D3414-041

Accept



Setup Start



Revision ID: C

Stop



Item Name: Lug Assembly

Start Date: 02/11/2009 Start Qty: ~~20.00~~ 2



Cust Item ID:

Required Date: 13/11/2009 Req'd Qty: 20.00



Customer:

Reference:

Approvals:

Process Plan:

RP

Date:

09-11-2

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3414

Rev C

100

0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3414-1

Dwg Rev: 5

Prog Rev: 5

2-Deburr if necessary

13 9-11-2

20

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

13 9-11-2

Work Order ID 53354

November 2, 2009 10:43:05 AM



Page 2

Item ID: D3414-041

Accept



Setup Start



Revision ID: C

Stop



Item Name: Lug Assembly

Start Date: 02/11/2009 Start Qty: 20.00



Cust Item ID:

Required Date: 13/11/2009 Req'd Qty: 20.00

Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

130

QC8- Inspect parts - second check

0.00



Brake NC

Memo

0.00

Brake NC

1-Deburr
2-Form using DT8254 as per Dwg D3414

140

QC8- Inspect parts - second check

0.00



Large Fab

Memo

0.00

Large Fab

1- Weld using location Jig DT8484 as per Dwg D3414
A/R S.S. welding rod Batch: M102421

2509/11/02

2509/11/03

25 took one for 5 Temp

25

EL 9-11-7 X25

Pto

W/O: 53354

WORK ORDER CHANGES

| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
|--------|----------|--------------------------------------------|----|--------|------|-------------------------------------|--------------------------|
| 9/11/2 | # 120 | Took Qty 1 Part for QC inspection template | S | 9/11/2 | (XL) | 69-11-10 | 02/10/2 |
| | | | | | | | |

Part No: D3414-041 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:

WORK ORDER NON-CONFORMANCE (NCR)

| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
|------|------|--------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Work Order ID 53354

November 2, 2009 10:43:05 AM



Page 3

Item ID: D3414-041

Accept



Setup Start



Revision ID: C

Stop



Item Name: Lug Assembly

Start Date: 02/11/2009 Start Qty: 20.00



Cust Item ID:

Required Date: 13/11/2009 Req'd Qty: 20.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

PD 09.11.09 (25)

160

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

25

25.11.10

165

Spray Painting per QSI005 4.2

0.00



SprayPaint

Memo

0.00

Spray Painting

Prime B 110199
Spray Paintat Delfleet Blue B 113171
Clear Delfleet B 113033

11 09 11 16 (8)

Work Order ID 53354

November 2, 2009 10:43:05 AM



Page 4

Item ID: D3414-041

Accept



Setup Start



Revision ID: C

Stop



Item Name: Lug Assembly

Start Date: 02/11/2009 Start Qty: 20.00



Cust Item ID:

Required Date: 13/11/2009 Req'd Qty: 20.00

Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

175

QC14- Inspect Spray Paint

0.00



QC

Memo

0.00

Quality Control

IT 09-11-17 (8)

190

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

Packaging

09/11/17 (8)

200

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/11/17 MF
09-11-17

Picklist Print

November 2, 2009 10:43:09 AM

Page 1

Work Order ID: 53354

Parent Item: D3414-041RevC

Parent Item Name: Lug Assembly

Comments:

Start Date: 02/11/2009

Required Date: 13/11/2009

Start Qty: 20.00

Required Qty: 20.00

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Remaining Qty To Pick | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|

M304S12GA

Purchased

No

100

sf

65.5900

30.4000



304/316 0.100" Sheet

IB 9-11-2

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

65.59

112290

1.59

112611

64

112290

20

D3414-3RevB

Manufactured

No

140

Each

42.0000

20.0000



Lug

20

9-11-5

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

42

50469

2

52599

20

52652

20

2

20

3

| | | | |
|------------------------------|--|--------------|---------|
| DART AEROSPACE LTD | | Work Order: | 53354 |
| Description: Lug Bracket | | Part Number: | D3414-1 |
| Inspection Dwg: D3414 Rev: C | | Page 1 of 1 | |

FIRST ARTICLE INSPECTION CHECKLIST

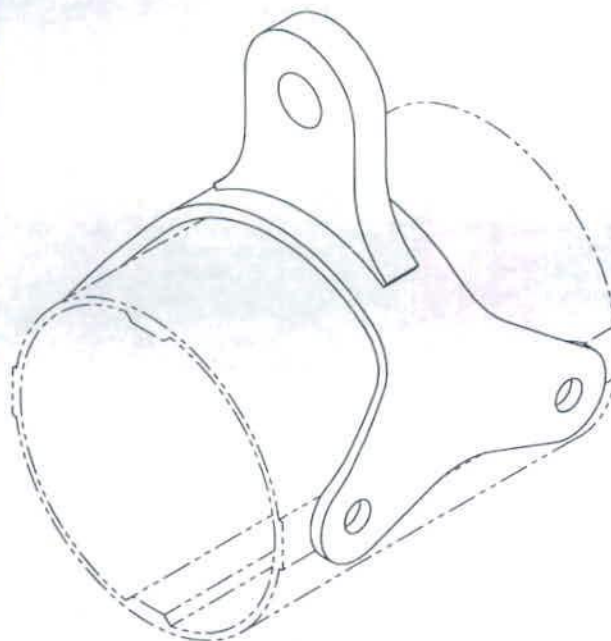
☒ First Article ☒ Prototype

| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|-------------------|---------------|------------------|--------|--------|----------------------|----------|
| Ø0.313 | +0.006/-0.001 | .315 | ✓ | | | |
| 1.19 | +/-0.030 | 1.186 | ✓ | | | |
| 1.00 | +/-0.030 | 1.008 | ✓ | | | |
| 3.38 | +/-0.030 | 3.378 | ✓ | | | |
| 5.350 | +/-0.010 | 5.351 | ✓ | | | |
| 6.23 | +/-0.030 | 6.232 | ✓ | | | |
| 2.500 | +/-0.010 | 2.502 | ✓ | | | |
| 0.37 | +/-0.030 | .369 | ✓ | | | |
| 0.100 | +/-0.010 | .1097 | ✓ | | | |
| | | | | | | |
| | | | | | | |
| | | | | | | |
| | | | | | | |
| | | | | | | |
| | | | | | | |
| | | | | | | |
| | | | | | | |
| | | | | | | |
| | | | | | | |
| | | | | | | |
| | | | | | | |
| | | | | | | |
| | | | | | | |
| | | | | | | |

| | | | |
|-----------------|---------------|---------------------|-----|
| Measured by: IB | Audited by: S | Prototype Approval: | N/A |
| Date: 9-11-2 | Date: 07/4/62 | Date: | N/A |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|----------------------------------|------------|----------|
| A | 08.02.28 | New Issue P/O D3414-041 | KJ/DD | |
| B | 09.05.27 | Dimensions updated per Dwg Rev B | KJ | |
| C | 09.10.16 | Dwg Rev updated to Rev C | KJ | |

| ITEM No. | QTY. -041 | PART NUMBER | DESCRIPTION |
|----------|-----------|-------------|--------------|
| 1 | X | D3414-041 | LUG ASSEMBLY |
| 2 | 1 | D3414-1 | LUG BRACKET |
| 3 | 1 | D3414-3 | LUG |



D3414-041 LUG ASSEMBLY

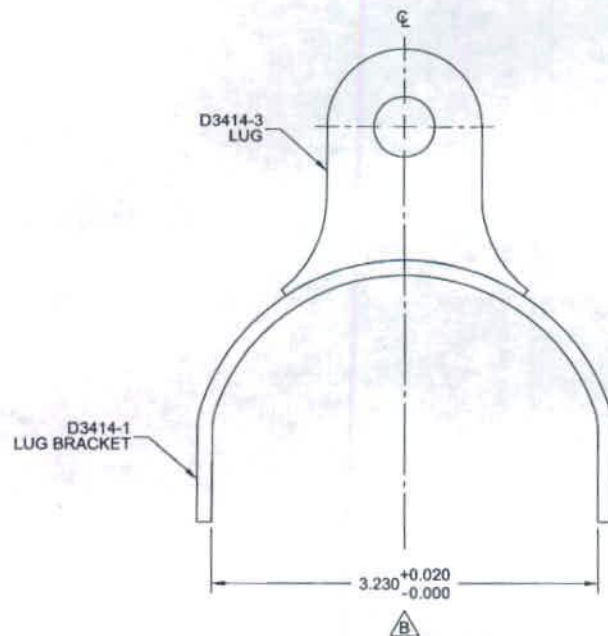
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3414-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.52 lbs

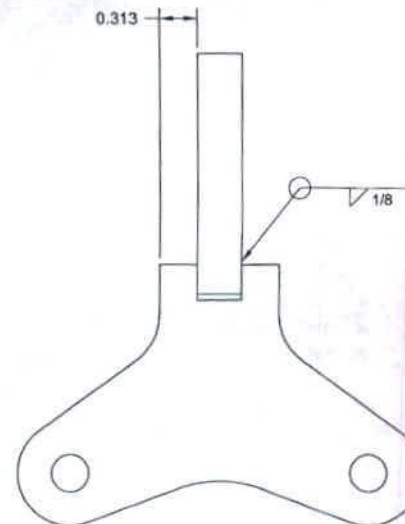
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 53354
BA 09-11-2

RELEASED
8/16/15

| | | | |
|------------|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------------|
| C | BREAK SHARP EDGES FOR -3 NOW 0.030-0.060 WAS 0.010-0.030 (ZIN A7-3) | CP | 09.06.17 |
| B | DRAWING REDRAWN IN SOLIDWORKS WITH CURRENT STANDARDS AND TRANSFERRED TO "B" SIZE BORDER. FLAT PATTERN FOR -1 INCREASED IN LENGTH TO PREVENT FOULING AT INSTL (SEE PAR198). FLAT SPOTS REMOVED FROM -1 (PART NOW "U" SHAPED) FOR EASE OF MANUFACTURE. B7-3 ADDED TOLERANCE TO 3.230 DIM. C2-3 1.12 DIM WAS 1.20. | AJS | 08.09.23 |
| A | NEW ISSUE | CP | 05.03.16 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | CP | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | CP | | |
| CHECKED | | DRAWING NO. | REV. C |
| MFG. APPR. | | D3414 | SHEET 1 OF 3 |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | LUG ASSEMBLY | NTS |
| DATE | 09.06.17 | COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD. | |



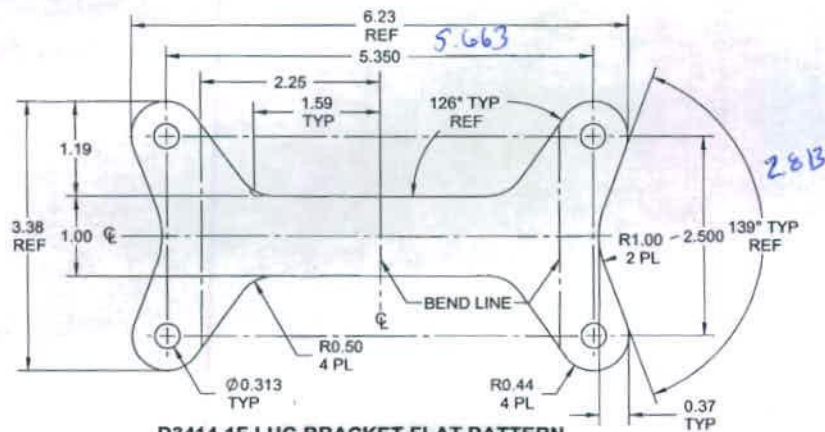
D3414-041 LUG ASSEMBLY



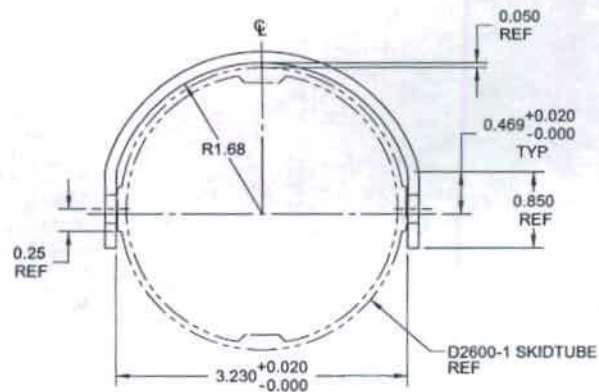
SHOP COPY
RETURN TO:
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 53354

RELEASED
09/06/17

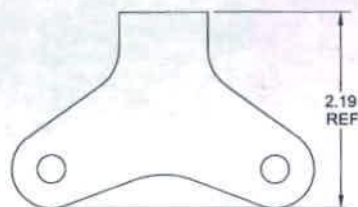
| | | | |
|------------|--------------------|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------------|
| DESIGN | CP | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | CP | | |
| CHECKED | <i>[Signature]</i> | DRAWING NO. D3414 | REV. C |
| MFG. APPR. | <i>[Signature]</i> | TITLE LUG ASSEMBLY | SHEET 2 OF 3 |
| DE APPR. | <i>[Signature]</i> | SCALE NTS | |
| DATE | 09.06.17 | <small>COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE LOANED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small> | |



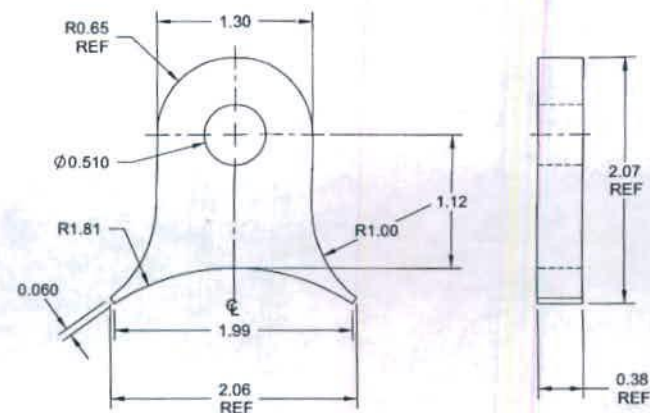
D3414-1F LUG BRACKET FLAT PATTERN



D3414-1 LUG BRACKET



SIDE VIEW FOR REF ONLY



D3414-3 LUG

NOTES:

1) MATERIAL: -1: AISI 304/316 STAINLESS STEEL SHEET, 12 GAUGE (0.100 THICK)
PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524
REF. DART SPEC. M304S12GA

-3: AISI 304/316 STAINLESS STEEL PLATE
PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524
REF. DART SPEC. M304S

2) FINISH: N/A

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: -1: 0.010 TO 0.020 MAX

-3: 0.030 TO 0.060 MAX

6) IDENTIFICATION: N/A

7) WEIGHT: N/A

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED
SUBJECT TO A
WITHOUT NOTICE
WORK ORDER
NO. 53354

RELEASED
29/06/06

| | | | |
|------------|----------|----------------------------------------|--------------|
| DESIGN | CP | DART AEROSPACE LTD | |
| DRAWN | CP | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | | DRAWING NO. | REV. C |
| MFG. APPR. | | D3414 | SHEET 3 OF 3 |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | LUG ASSEMBLY | NTS |
| DATE | 09.06.17 | COPYRIGHT © 2005 BY DART AEROSPACE LTD | |

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSES NOT AUTHORIZED BY DART AEROSPACE LTD.

